

Date: Monday, 24/12/2007 12:17:58 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-642-611

Job Number : 36159

Estimate Number : 10804

P.O. Number :

This Issue : 24/12/2007 S.O. No. :

Prsht Rev. : NC

First Issue : 05/12/2007 Type : LANDING GEAR

Previous Run : 35179

Written By : Checked & Approved By : 

Comment :

Part Number : D206642611

Drawing Number : REWORK/SCRAP ECN 1070

Project Number :

Drawing Revision :

Material :

Due Date : 12/12/2007 Qty: 1 Um: Each

Additional Product

Job Number:



<b>DART</b>		TEL.: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-642-611	CHG	CHG001
DESC.	Float Skidtube LH	STC	SH98-4
LOT	B24803	STC	SA00475SE
MODEL	Bell 206A/B	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

Seq. #: Machine Or Operation: Description :

1.0 D206642611 Skidtube LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Skidtube LH  
 ORIGINAL B/N 24803  
 FROM OFFSHORE

①  
 BUE FILES  
 08-01-10 RJ

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

INSTALL  
 PLUG-  
 AND

- a) Drill out existing mid float welded spacers. 3 spacers per skidtube  
 b) Fill drilled out holes with weld. 6 holes total  
 c) Drill new mid float bag holes (on an angle) per D3288 Rev F. 12 places per skidtube

M 106330

DP 8-1-16 BE 08/02/05  
 (weld 100) M 105671 (plus)  
 6061-76

3.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION



PD 0802-112

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



S 08 02/11/08

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1



REMOVE ALL EXISTING PARTS  
 SAND LIGHTLY FOR RE-PAINT

3 08-02-12

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: D206-642-611

Job Number: 36159

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

POWDER COATING

POWDER COATING



M10700 S



(1X)

Comment: POWDER COATING

RE-PAINT PER QSI005

M-L

08/02/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-12

(X1)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D3683-1 inserts. Plug inserts with MS27039C1-05 (or AN3C3A bolt) and AN960C10L washers. 12 places per skidtube.  
e) On the aft cap, replace the NAS1515H3L with D3672-1 washers. 2 places

INSTALL ALL EXISTING PARTS (WEARPLATES ETC)  
PER DRWG D3288 REV.F  
INDICATE ANY NEW PARTS USED:

\* see Attached paper ->

10.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)  
INSERT B 36319

HL

11.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)  
SCREW  
(OR AN3C3A) M107008

HL

08-02-12 (X1)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Part list:

Quantity:

Part (batch no):

Item.

①	D2646/B36184	wearshoe
①	D3535-15/B36653	WEARSHOE
①	D3535-21/B31991	WEARSHOE
①	D3535-35/B36194	WEARSHOE
①	D3536-15/B33964	GASKET
①	D3536-21/B31995	GASKET
①	D3536-35/B36609	GASKET
①	D3536-41/B31997	GASKET
<del>78</del> 78	AN960C10-L / M107008	washer✓
①	AN960C416 / M100993	washer✓
96	AN3C-4A / M 107008	bolt.
①	AN4C-5A / M104936	bolt.
①	D3537-3 / B33285	wearpad.
7	D3537-1 / B36714	wearpad.
②	D3672-1 / B34470	washer✓

JS 08-02-13 (XV)

Date: Monday, 24/12/2007 12:17:58 PM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-611

Job Number: 36159

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10L

washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
washer M107008

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/20

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

CHANGE THE FOLLOWING IN KITS:

Changes to "pick" kit

- ✓ a) REMOVE NAS1515H5 washer replace with D3672-5. Qty 16 M101064 x16
- ✓ b) REMOVE NAS1515H5L washer replace with D3672-7. Qty 8 M101925x5 M100680x3
- ✓ c) REMOVE NAS1515H4L washer replace with D3672-3. Qty 24 M101428 x24
- d) ADD MS21250-03004 bolt. Qty 6
- ✓ e) REMOVE NAS1515H3L washer replace with D3672-1. Qty 18 M103325 x8. There was only 8 in package.
- f) ADD AN960JD10 washer. Qty 6 ~~M103325 x8~~

15.0

D36725

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
PHENOLIC WASHER 35521

16.0

D36727

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
PHENOLIC WASHER 35522

17.0

D36723

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)  
PHENOLIC WASHER 34471

08/02/20 (X)  
08/02/20 (X)  
08/02/20 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 08/02/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36159

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D36721

PHENOLIC WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)  
PHENOLIC WASHER

31470

AS 08/02/20 (X)

19.0

MS21250 03004

HIGH STEEL BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)  
HIGH STEEL BOLT

M100277

AS 08/02/20 (X)

20.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Washer

106167

AS 08/02/20 (Y)

21.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08-02-20 (V)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D206-642-611  
USING NEW B/N  
CHG 003  
Location: \_\_\_\_\_  
PPP Rev: Rev B

8/2/22 50 (X)

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/25 (i)

Job Completion



2008/2/25 (1)

B36159



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**L Lacelle**

---

**From:** Peter Hum [phum@dartaero.com]  
**Sent:** December 21, 2007 11:33 AM  
**To:** 'L Lacelle'  
**Subject:** RE: ECN1070 / 1063 for change record #003

Hi Linda,

I am writing this re-work with the assumption that the float skidtubes are painted and basically complete per the old CHG

Therefore to re-work these to CHG 003

- a) Drill out existing mid float welded spacers. 3 spacers per skidtube
- b) Fill drilled out holes with weld. 6 holes total
- c) Drill new mid float bag holes (on an angle) per D3288 Rev F. 12 places per skidtube
- d) Install D3683-1 inserts. Plug inserts with MS27039C1-05 (or AN3C3A bolt) and AN960C10L washers. 12 places per skidtube.
- e) On the aft cap, replace the NAS1515H3L with D3672-1 washers. 2 places

Changes to "pick" kit

- a) REMOVE NAS1515H5 washer replace with D3672-5. Qty 16
- b) REMOVE NAS1515H5L washer replace with D3672-7. Qty 8
- c) REMOVE NAS1515H4L washer replace with D3672-3. Qty 24
- d) ADD MS21250-03004 bolt. Qty 6
- e) REMOVE NAS1515H3L washer replace with D3672-1. Qty 18
- f) ADD AN960JD10 washer. Qty 6

For reference please see D3288 Rev. F and Installation Instructions D206-642 Rev. L

Peter

-----Original Message-----

From: L Lacelle [mailto:llacelle@dartaero.com]  
Sent: December 20, 2007 2:46 PM  
To: Peter Hum (Peter Hum)  
Subject: FW: ECN1070 / 1063 for change record #003

Peter,

Could you please let me know what the rework scheme will be...642-641's returned from airlog/offshore

Thx  
LL

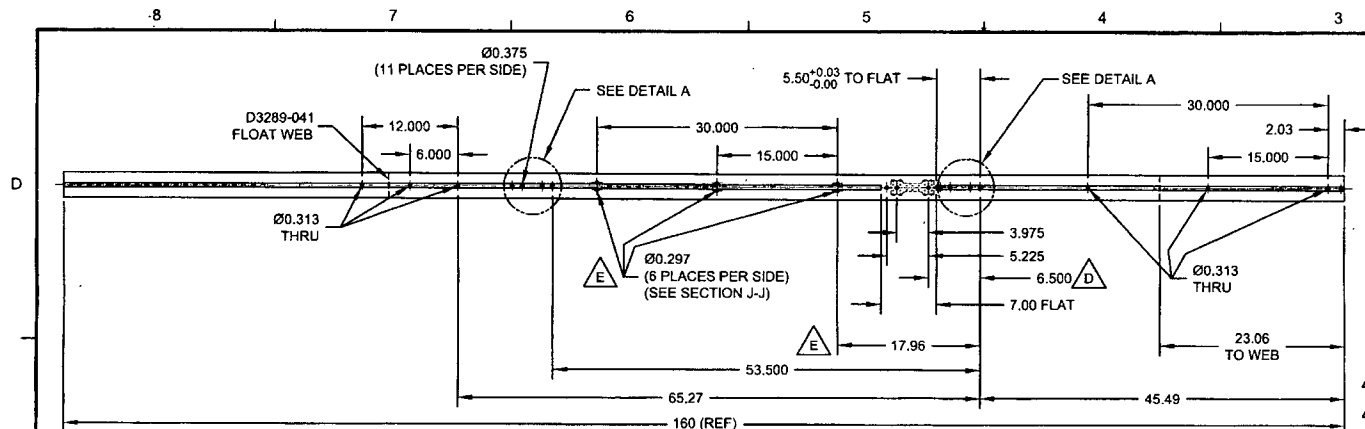
-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]  
Sent: December 20, 2007 1:50 PM  
To: Linda Lacelle (E-mail)  
Subject: ECN1070 / 1063 for change record #003

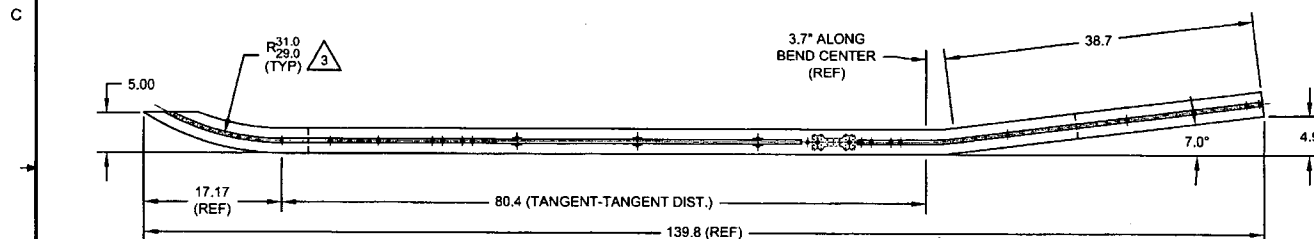
Linda,

All four skidtubes need to be reworked, B35179, 35180, 36159, 36160 per ecn 1070

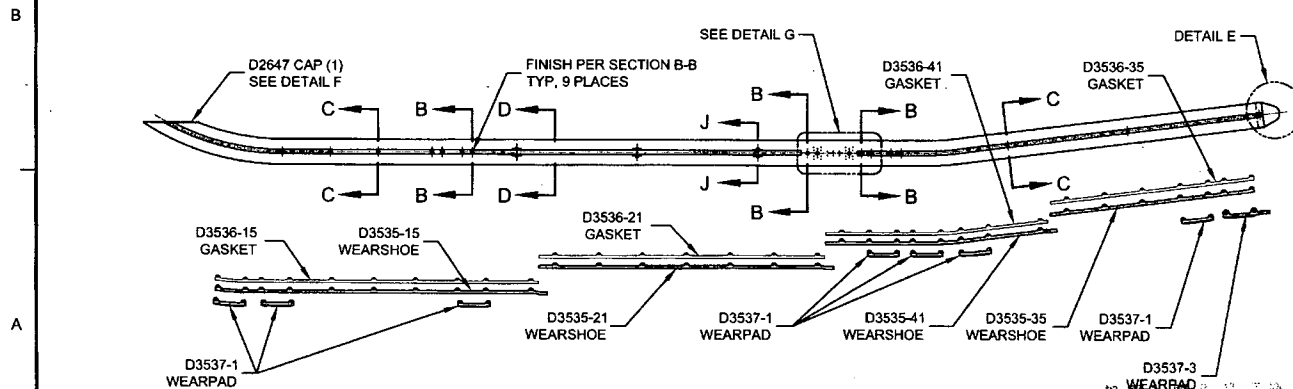
Kim Johnston  
Dart Aerospace Ltd.  
Engineering Clerk  
Document Control  
Email: kjohnston@dartaero.com  
Tel: 613-632-5200



**D3288-041 DRILLING/WEB ASSEMBLY DETAIL**



**D3288-041 BENDING DETAIL**



**D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY**

Qty	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
8	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN560C416	WASHER
78	AN560C10L	WASHER
2	CCR2645S3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

**GENERAL NOTES:**

- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCOYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES.
- DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- WELDING: PER DART QSI 004.

F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS. SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DL		
CHECKED	DL	DRAWING NO.	REV. F
MFG. APPR.	REP	D3288	SHEET 1 OF 2
APPROVED	REP	TITLE	SCALE
DE APPR.	REP	SKIDTUBE ASSEMBLY	1:15
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

636159

**Dart Aerospace Ltd**

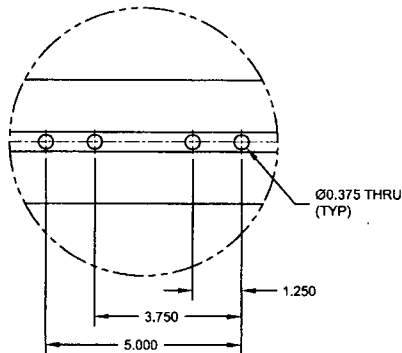
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

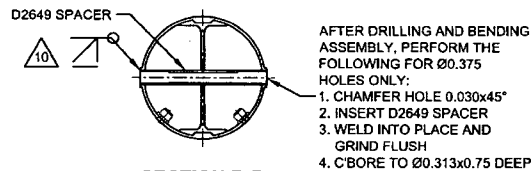
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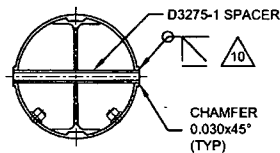
**NOTE:** Date & initial all entries



**DETAIL A: DRILL DETAIL**



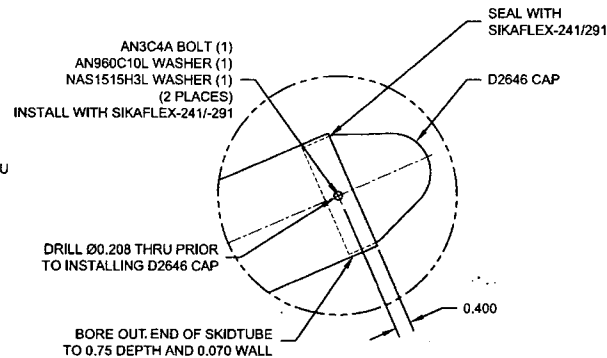
**SECTION B-B**  
FOR Ø0.375 HOLES ONLY  
(TYP, 9 PLACES)



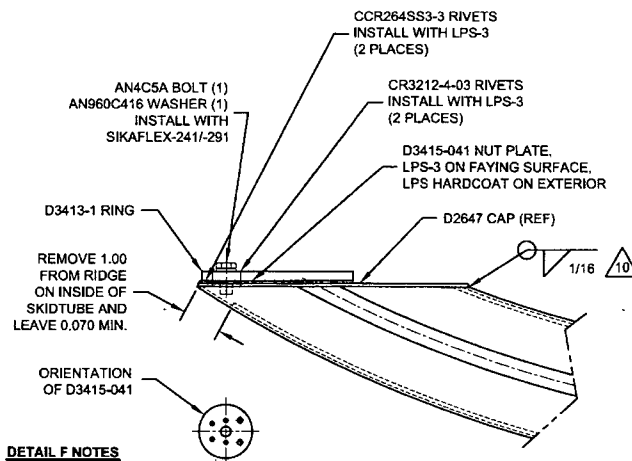
**SECTION C-C**  
FOR Ø0.313 HOLES ONLY  
(TYP, 6 PLACES)



**SECTION D-D**  
FOR WEARSHOES INSTALL ONLY  
(TYP, 32 PLACES)



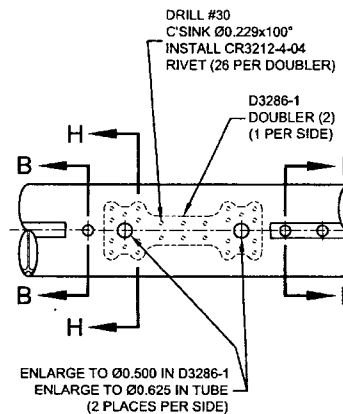
**DETAIL E**



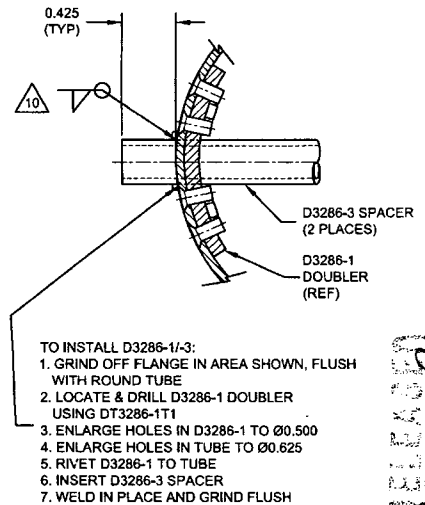
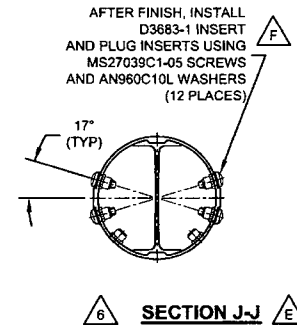
**DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

**DETAIL F: END FINISHING DETAIL**



**DETAIL G**  
SCALE 1:5



**SECTION H-H**  
NOT TO SCALE

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	JS	D3288	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	AF	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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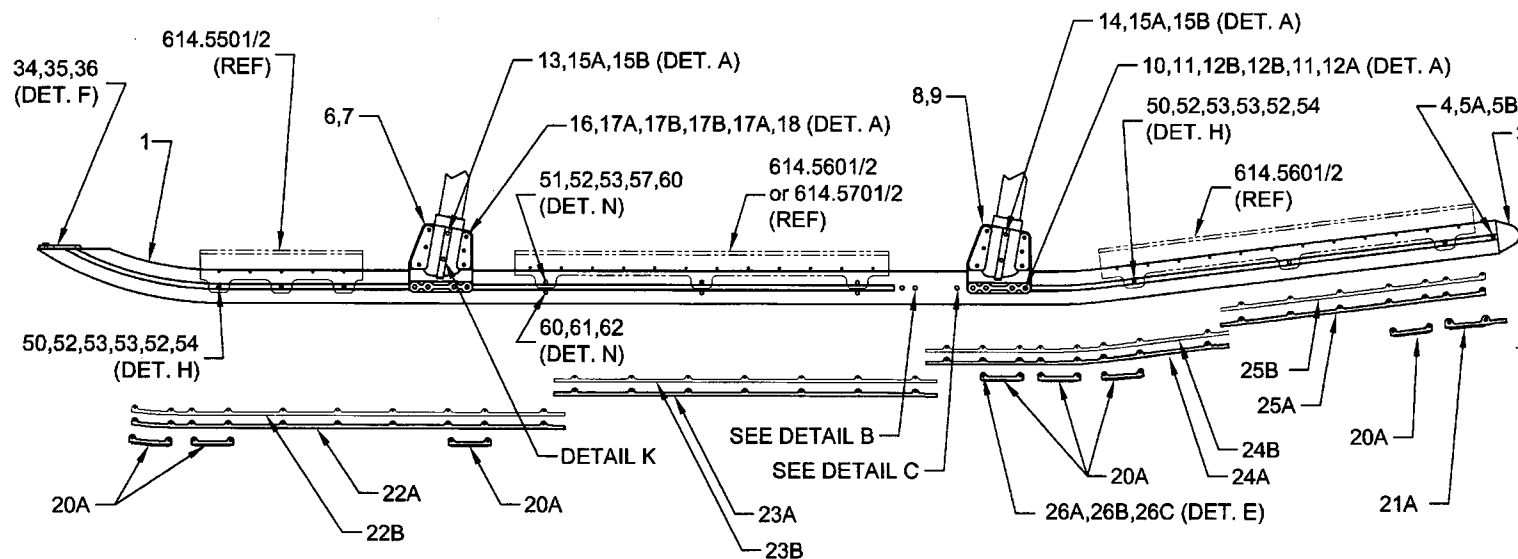
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

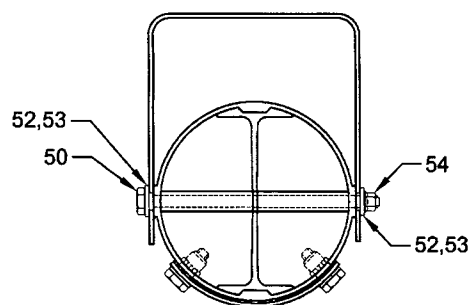
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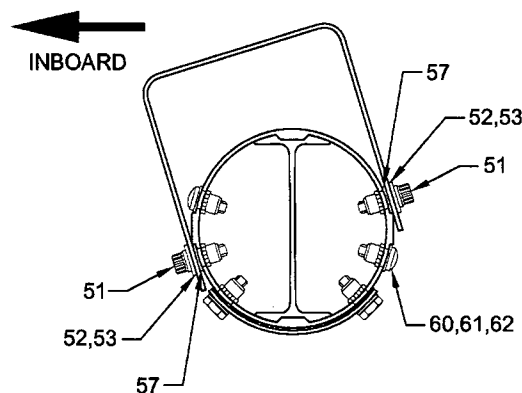
# **206 A/B FLOAT SKIDTUBES (TRI-BAG FLOATS)** (D206-642-611/-612/-613/-614)



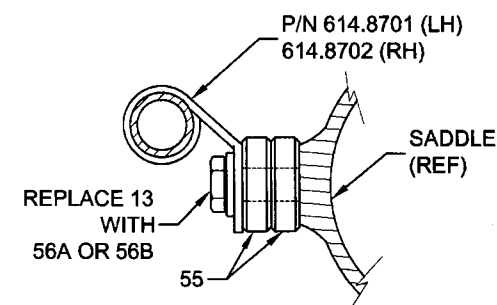
**DETAIL H**



**DETAIL N**



**DETAIL K**



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Revision: **L**

Date: 07.10.25

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 2/20/2008 1:41:48 PM

User: Kim Johnston

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-611

Job Number: 36159

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D36721

PHENOLIC WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)  
PHENOLIC WASHER

19.0

MS21250 03004

HIGH STEEL BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
HIGH STEEL BOLT

20.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Washer

21.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-611

USING NEW B/N

CHG 003

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Paperwork & Label  
PER CHG 003

08.02.20  
RJ

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

24.0

EMP COST ADJ

Employee Labour Cost Adjustment



Comment: Sub-Contracting Employee Labour Cost Adjustment

Job Completion

